

SPLIT 2

Work Order ID 65921-1

Thursday, January 27, 2011 10:47:15 AM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 1/27/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

11

Date: 11-01-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3916

A

100

Weld per dwg A/R S.S. rod Batch: 1114649 0.00



Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- \*\*\* Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*
- 3- Trim access tube material to finish size as per dwg D3916
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605
- 5- weld bushing as per dwg D3916
- 6- grind welds flush

SAD 11-02-03

11-02-11 (2x)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Subtotal

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65921

Thursday, January 27, 2011 10:47:15 AM



Page 2

Item ID:	D3916-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Rib Assembly				Stop	
Start Date:	1/27/2011	Start Qty:	6.00			
Required Date:	2/4/2011	Req'd Qty:	6.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00				<i>(X2)</i>			
130  Packaging Packaging	Identify as per dwg & Stock Location:  <i>Badget cell</i> Memo	0.00  0.00							<i>11/02/11 (2x)</i>
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<i>11/02/14</i> <i>Mr</i> <i>11-02-11</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, January 27, 2011 10:47:28 AM

Page 1

Work Order ID: 65921

Parent Item: D3916-041

Parent Item Name: Rib Assembly



Start Date: 1/27/2011

Required Date: 2/4/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1 Manufactured No



Bushing

Location

Loc Qty

Loc Code

WA

9

54072

9

M304TS0.750W.049 Purchased No



304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT

55.13726794

113763

0

114323

8.15031894

114677

0.00001

114835

0.000039

116319

25.1993

116509

21.7876

MAT017

3.68448E-05

114298

3.6845E-05

WA

36.9458

114992

11.0693

115260

25.8765

7

42



B65709 (2x) 11/02/10

B66125 (2x)

4.166

26.31158

61.3938



11/02/10

7116719

END BAR  
Scrap

61.3938

3.000

64.3938

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

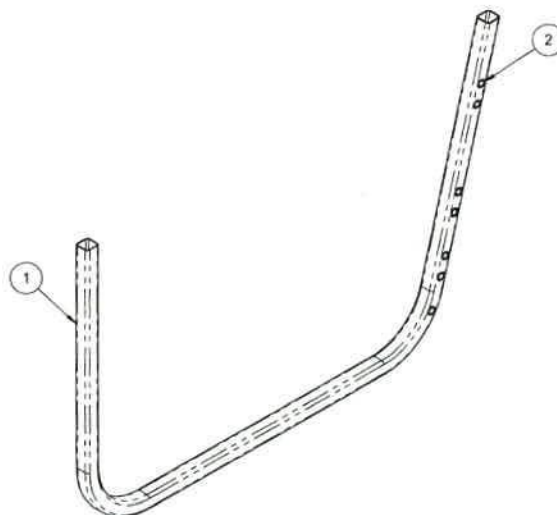
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

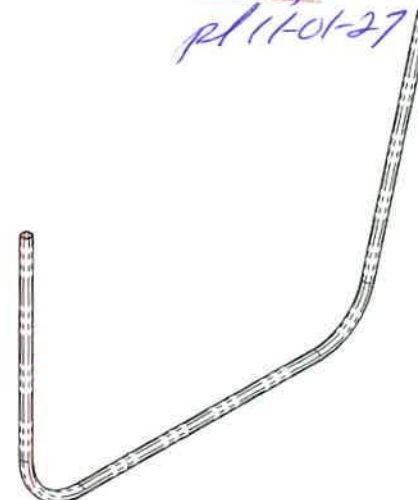
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**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



**D3916-041 RIB ASSY**



**D3916-5 LIGHT RIB**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 05921

*pl 11-01-27*





OK 10.12.21  
~~UNDER REVIEW~~

ADDITION OF HOLE + BUSHING  
ON D3916-041-1 RIBS.

**RELEASED**

2010-03-12

*MP*

A.	NEW ISSUE	JPH	10.03.04	
REV.		DESCRIPTION	BY DATE	
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3916	SHEET 1 OF 4
APPROVED			TITLE	SCALE
DE APPR.			RIB ASSY, 350 BASKET	NTS
DATE	10.03.04		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

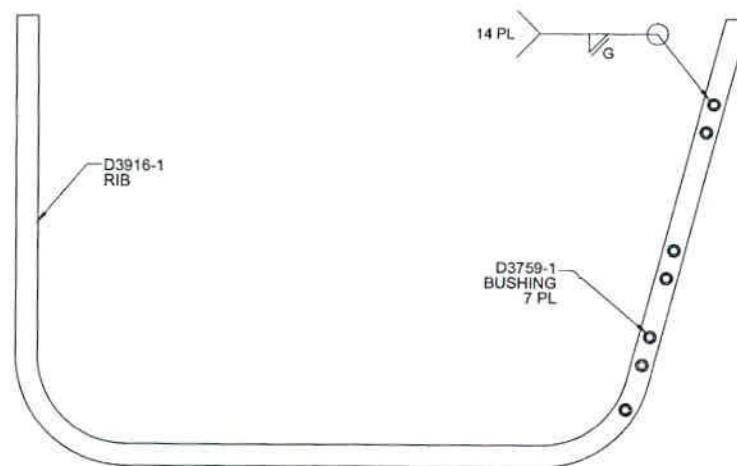
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**NOTE:** Date & initial all entries



W1065921



D3916-041 RIB ASSY

**RELEASED**  
2010-03-12  
JMP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	N/A	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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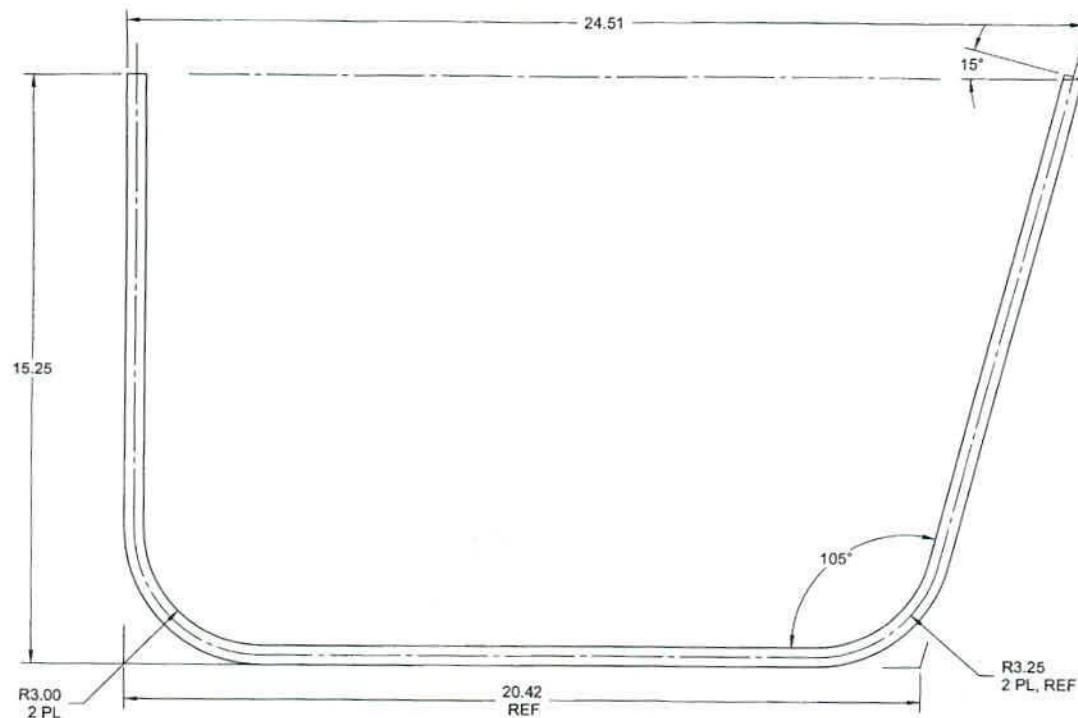
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





9 D3916-5 LIGHT RIB

u605921

RELEASED  
2010-03-12  
JH

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D3916	SHEET 4 OF 4
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	RIB ASSY, 350 BASKET	NTS
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